



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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006783

646.3301
Job Sheet 186242



Part No: 646.3301

Job Qty: 2 ea

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 11/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 646.3300 REV NC3 IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.07 AS PER
DWG NC3 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		11/28/18	0.00	0.00	Start Up Stores/Pkg-2		NOV 29 2018
110	Packaging	2 pcs		11/28/18	0.00	0.00	Packaging1-1		NOV 29 2018 DAS
120	Small Fab	2 pcs		11/28/18	0.00	2.78	Small Fab-1		DAS 36
130	QC	2 pcs		11/28/18	0.00	0.00	QC5		DAS 9-89
140	Packaging	2 pcs		11/28/18	0.00	0.00	Packaging3-1	CKK D18	DAS 9-89
150	QC21-SA	2 Ea		11/28/18	0.00	0.00	QC21		DAS 9-89

Part Op 120 - TWO fastener must be install finger-tight (see note 9) Assemble as per dwg and apply loctite 598 on all faying
Descriptions: surfaces shown on dwg per note 7. exp. date:

140 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3310 CCK 22	LH Half - Upper Cutter Assembly	2 Ea (1 ea)	90-Start up Operation	5108199.
646.3311 22	RH Half - Upper Cutter Assembly	2 Ea (1 ea)	90-Start up Operation	5108605.
646.3312 15A	Center Plate	2 Ea (1 ea)	90-Start up Operation	3043341
646.3313 23	Upper Guide	2 Ea (1 ea)	90-Start up Operation	5043387
646.3314 102	Blade	2 Ea (1 ea)	90-Start up Operation	5052415.
646.3315 102	Blade	2 Ea (1 ea)	90-Start up Operation	5051508
646.3316 102	Blade	2 Ea (1 ea)	90-Start up Operation	5053063
AN3-12A	Bolt	4 Ea (2 ea)	90-Start up Operation	5095429
AN3-14A	Bolt	2 Ea (1 ea)	90-Start up Operation	5118190.
MS21042L08	Nut	36 Ea (18 ea)	90-Start up Operation	5100409
MS21042L3	Nut	6 Ea (3 ea)	90-Start up Operation	5094592
MS27039-08-19	Screw	36 Ea (18 ea)	90-Start up Operation	5104359
NAS1149F0332P	Washer	12 Ea (6 ea)	90-Start up Operation	5131201
NAS1149FN832P	Washer	72 Ea (36 ea)	90-Start up Operation	5107196

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	646.3310	2	10	0
	646.3311	2	11	0
	646.3312	2	9	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

646.3313	2	2	0
646.3314	2	4	0
646.3315	2	4	0
646.3316	2	5	0
AN3-12A	4	88	0
AN3-14A	2	314	0
MS21042L08	36	1,559	0
MS21042L3	6	1,944	0
MS27039-08-19	36	1,544	0
NAS1149F0332P	12	1,657	0
NAS1149FN832P	72	2,415	0

Part Specifications

Specifications could not be found.

Plex 11/13/18 10:34 AM Dart.lajeunesse.marie



Container No: S133408



Part: 646.3301

Job No: 186242

Serial No/Batch: S133408

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/29/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																											
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